

Date: Monday, 9/10/2007 1:27:47 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 STEP END PLATE		
Job Number	: 34485					
Estimate Number	: 11021					
P.O. Number	: N/A		Part Number	: D2734		
This Issue	: 9/10/2007 S.O. No. : N/A		Drawing Number	: D2734 REV B		
Prsh Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: B		
Previous Run	: 33861		Material	: N/A		
Written By			Due Date	: 10/3/2007 Qty: 200 Um: Each		
Checked & Approved By						
Comment	: Est:D 01.06.08 Removed Deburr EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S063	5052-H32 .063 Sheet	
		Comment: Qty.: 0.0656 sf(s)/Unit Total : 13.1250 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.063" thick (M5052H32S.063)	180 PIECES Batch: M103755 → HB 07-09-12 M19296
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2734 Dwg Rev: B Prog Rev: B	204 07/09/13 204
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 HB 07-09-13
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	 QSP 015
		Comment: SECOND CHECK	En 07/04/13 (X204) counter
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Form per drawing D2734	8B 07/10/08 (204)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/01/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



cont'd

Comment: INSPECT WORK TO CURRENT STEP

5/07/10/09 4204

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WTA3

5/07-10-12

204

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

5/07-10-12

204

Job Completion



5/07-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34485
Description: End Plate	Part Number:	D2734
Inspection Dwg: D2734      Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article  Prototype

Measured by:	<u>LR</u>	Audited by:	<u>Esp</u>	Prototype Approval:	N/A
Date:	<u>07-09-12</u>	Date:	<u>07/09/13</u>	Date:	N/A

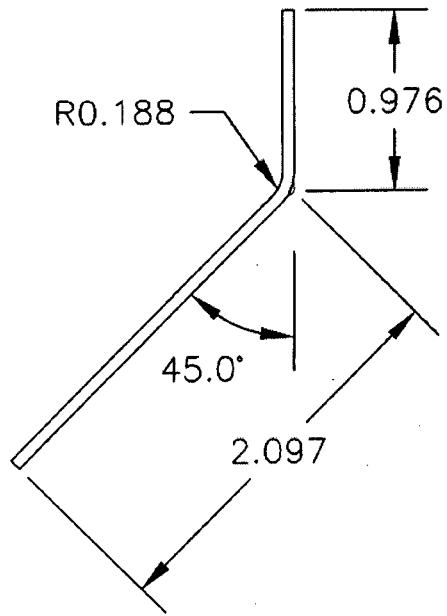
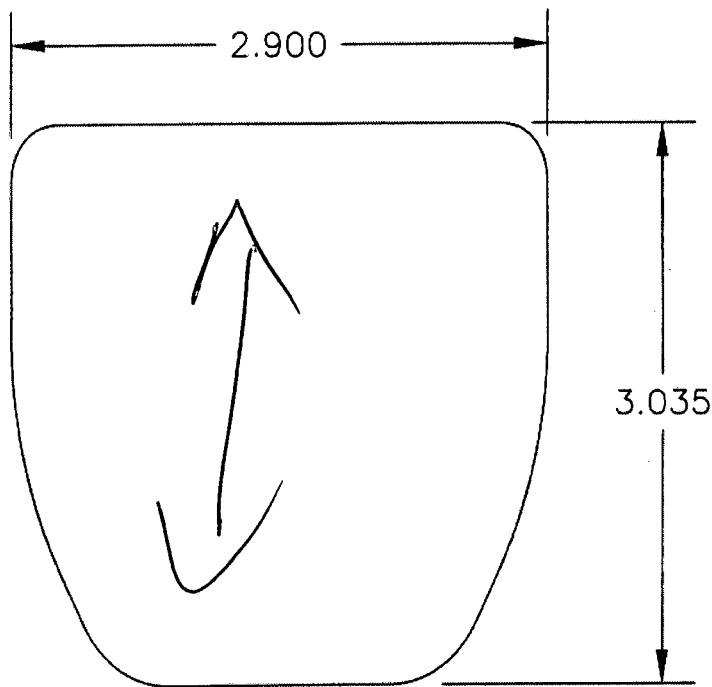
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>RH</i>	APPROVED <i>SJ</i>	DRAWING NO. D2734	REV. B SHEET 1 OF 1
DATE 98.10.05		TITLE END PLATE	SCALE 1:1
A	97.12.10	NEW ISSUE	
B	98.10.05	0.976 WAS 1.016, 2.097 WAS 2.137	

**RELEASED**

98/10/05 KE

BEND DETAILFLAT PATTERN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34485*

MATERIAL: 5052-H32 (QQ-A-250/8) OR  
6061-T6 (QQ-A-250/11) 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED